

Date: Wednesday, 2/8/2006 7:06:47 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 25731	Part Number	: D314095
Estimate Number	: 11467	Drawing Number	: D3140 REV C
P.O. Number	: NIA	Project Number	: N/A
This Issue	: 2/8/2006 S.O. No. : NIA	Drawing Revision	: C
Prsht Rev.	: NC	Material	: NIA
First Issue	: NIA	Due Date	: 2/15/2006
Previous Run	: NIA	Qty:	12 Um: Each
Written By	: <u>SEE COMMENT BELOW</u>		
Checked & Approved By	: <u>W</u>		
Comment	: Est. A02.04.30 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.1549 sf(s)/Unit Total : 1.8585 sf(s)
 2024-T3 .032 sheet
 Matl: 2024-T3 (QQ-A-250/4) .032" thick
 (M2024T3S.032) 6.40" x 3.81" flat pattern ref.

Batch M12758

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut as per dwg D3140

mul 06/02/08

12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Cut as per dwg D3140
 Deburr. No sharp edges
 Form as per dwg

make by hand

Form: SB 06/02/08

12

mul 06/02/08

12

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

J 06-02-09

P70

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

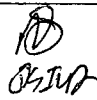
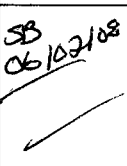

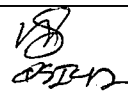

FF. 06. 02. 17

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 02/02/09

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-09	3	Parts are .090 Short on 2.1 dim. Parts are 2.010 Top dim is important and is good.		Parts are acceptable bottom dim	SB 06/02/09 	 06-02-09		 06-02-09

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 25731

Part Number: D314095

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 02 17

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 06/02/17 (12)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/20 (12) DP 06/02/20 (12)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GRAIN
DIRECTION



3.810

6.40

REFERENCE ONLY